

ABSTRACT

A method and a plant for manufacturing a belt structure of a green tire are described, wherein the portions (49a, 49b) of the belt strips (19a, 19b) constituting the belt structure are produced in a substantially continuous manner immediately upstream of at least one assembly drum (50, 51).

Such method and plant are integrated respectively in a method and in a plant for manufacturing, in a substantially continuous manner, a belt package and a crown structure incorporating the belt structure thus obtained.

The method for manufacturing the belt package comprises the subsequent formation on the belt structure of a rubber mixture layer incorporating a plurality of reinforcing cords (5), whereas the method for manufacturing the crown structure comprises the subsequent assembly of a tread (7) on the belt package thus formed. The rubber mixture layer incorporating the reinforcing cords (5) and the tread (7) are both manufactured in a substantially continuous manner immediately upstream of at least one assembly drum (66). According to the invention, a high and constant quality level of the belt structure, of the belt package and of the crown structure are ensured, achieving at the same time a reduction in production costs and an increase in the production capacity of the plant.

Fig. 1